

Work Order ID 117466

117466

April

Page 1

April-24-14 11:32:08 AM

Item ID: D412-776-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Glareshield

Start Date: 5/01/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/01/14 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan: MUS Date: 4-04-30

Tooling:

Date:

Stop

NR2

QC: Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN D412-776

Rev B

CL 15-06-02

100 Document Control 0.00

100

DAS
6
9-89

DAS
02
9-89

DC Memo 0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D412-776-011

CHG001

IIN 10 2015

110 Pick Kit 0.00

110

MAY 28 2015

Packaging Memo 0.00

Packaging

DAS
27
9-89

DAS
28
9-89

120 QC4- 100% Inspect kits for completeness 0.00

120

DAS
6
9-89

DAS
02
9-89

QC Memo 0.00

Quality Control

JUN 10 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 117466

117466

Page 2

April-24-14 11:32:08 AM

Item ID: D412-776-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Glareshield

Start Date: 5/01/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/01/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								DAS 02 9-89
Packaging	Memo	0.00				DAS 6 9-89			
Packaging	Identify and pack for shipping as per PPP D412-776-011 Location: <u>631</u> PPP Rev: _____								JUN 16 2015
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00				ML5			JUN 18 2015
Quality Control									

ML5 JUN 17 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

April-24-14 11:32:04 AM

Page 1

Work Order ID: 117466

117466

Parent Item: D412-776-011

D412-776-011

Parent Item Name: Glareshield

Start Date: 5/01/14

Required Date: 5/01/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-05-12 new issue DD verified by: LL
IPP Rev:B 08-07-14 revB as per dwg DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-3A		Purchased	No			120	Each	349.0000	6	6		DAS 27 9-89	
AN3-3A									**				
Bolt													DAS 28 9-89
DAS 02 9-89													
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST350				349					
				m126249				1	m129591	6			
				m127815				98					
				m128429				250					
AN3-5A		Purchased	No			120	Each	1,003.000	10	10		DAS 27 9-89	
AN3-5A									**				
Bolt													DAS 28 9-89
DAS 02 9-89													
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				GA				49					
				117423				49					
				ST511				836	m131420	10			
				m126559				836					
				ST512				118					
				124561				118					
AN970-3		Purchased	No			120	Each	449.0000	4	4		DAS 27 9-89	
AN970-3									**				
Washers													DAS 28 9-89
DAS 02 9-89													
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST508				449					
				m127432				49					
				m128057				400					

APR 23 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

April-24-14 11:32:05 AM

Page 2

Work Order ID: 117466

117466

Parent Item: D412-776-011

D412-776-011

Parent Item Name: Glareshield

Start Date: 5/01/14

Required Date: 5/01/14

Start Qty: 1.00

Required Qty: 1.00

D3690-041

Manufactured No

120

Each

0.0000

1

1

D3690-041

Glareshield Assembly

D3699-041

Manufactured No

120

Each

6.0000

1

1

D3699-041

Support Assembly

DAS
02
9-89

Location

Loc Qty

Loc Code

ST248A

6

84076

6

D3699-042

Manufactured No

120

Each

4.0000

1

1

D3699-042

Support Assembly

DAS
02
9-89

Location

Loc Qty

Loc Code

ST247A

4

84846

4

MS20426AD3-3

Purchased No

120

Each

6,969.000

12

12

MS20426AD3-3

RIVET

DAS
02
9-89

Location

Loc Qty

Loc Code

ST334

698

123352

698

ST553

6271

M128754

6271

MB1624

DAS
27
9-89

DAS
28
9-89

DAS
27
9-89

DAS
28
9-89

APR 23 2015

DAS
27
9-89

DAS
28
9-89

APR 23 2015

DAS
27
9-89

DAS
28
9-89

APR 23 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge		
☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other		

Picklist Print

April-24-14 11:32:06 AM

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Work Order ID: 117466

Parent Item: D412-776-011

Parent Item Name: Glareshield

117466

D412-776-011

Start Date: 5/01/14

Required Date: 5/01/14

Start Qty: 1.00

Required Qty: 1.00

MS21042L06

Purchased

No

120

Each

509.0000

11

11

MS21042L06

Nut

DAS
02
9-89

Location

Loc Qty

Loc Code

ST314

509

m127304

20

m127831

89

m128401

200

m128754

200

**

DAS

27

9-89

DAS

28

9-89

MS21075L08

Purchased

No

120

Each

383.0000

6

6

MS21075L08

ANCHOR NUT

DAS
02
9-89

Location

Loc Qty

Loc Code

ST318

383

M126145

33

M128635

200

M128813

150

**

DAS

27

9-89

DAS

28

9-89

MS35206-228

Purchased

No

120

Each

284.0000

11

11

MS35206-228

SCREW

DAS
02
9-89

Location

Loc Qty

Loc Code

ST288

284

120560

284

**

DAS

27

9-89

DAS

28

9-89

NAS1149D0332J

Purchased

No

120

Each

5,621.000

12

12

NAS1149D0332J

Washer

DAS
02
9-89

Location

Loc Qty

Loc Code

ST294

621

m128606

621

ST510a

5000

m128612

5000

**

DAS

27

9-89

DAS

28

9-89

APR 23 2015

April-24-14 11:32:07 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ </td> <td style="width: 33%;"> Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ </td> <td style="width: 33%;"> Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ </td> <td style="width: 33%;"> Engineering ☐ Quality ☐ Other ☐ </td> </tr> </table>	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

April-24-14 11:32:07 AM

Page 4

Work Order ID: 117466

Parent Item: D412-776-011

Parent Item Name: Glareshield

117466

D412-776-011

Start Date: 5/01/14

Required Date: 5/01/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN616J

Purchased

No

120

Each

469.0000

11

11

NAS1149DN616.J

Washer

DAS

27

9-89

DAS

28

9-89

DAS

02

9-89

Location

ST293

Loc Qty

469

Loc Code

M127726

469

APR 23 2015

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WORK ORDER NON-CONFORMANCE / UPDATE

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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53.5 Weight and Balance

The net weight increase associated with the D412-776-011 Replacement Glareshield Kit is negligible.

53.6 Parts List

Qty -011	Part Number	Description
X	D412-776-011	REPLACEMENT GLARESHIELD KIT
1	D3690-041	GLARESHIELD ASSEMBLY
1	*D3690-1	GLARESHIELD
1	*D3697-041	TUBE ASSEMBLY
1	*D3698-1	SUPPORT ANGLE
6	*AN960JD3	WASHER (or NAS1149DN332J)
35	*MS20470AD3-4	RIVET
2	*MS20426AD3-4	RIVET
1	D3699-041	SUPPORT ASSEMBLY
1	*D3699-1	SUPPORT
1	*MS21059L3	NUTPLATE
2	*MS20426AD3-3	RIVET
1	D3699-042	SUPPORT ASSEMBLY
1	*D3699-2	SUPPORT
1	*MS21059L3	NUTPLATE
2	*MS20426AD3-3	RIVET
6	AN3-3A	BOLT
10	AN3-5A	BOLT
12	AN960JD10L	WASHER (or NAS1149D0332J)
11	AN960JD6L	WASHER (or NAS1149DN616J)
4	AN970-3	WASHER
12	MS20426AD3-3	RIVET
11	MS21042L06	NUT
6	MS21075L08	NUTPLATE
11	MS35206-228	SCREW

(NOTE: PARTS IN BOLD TYPE CONSTITUTE PICK LIST FOR D412-776-011 KIT)

* PART IS INCLUDED WITH ASSEMBLY ABOVE